



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-101
Job Sheet 180756



Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/13/18

Job Tracking No:

Due Date: 8/3/18

Created By: Jesse White

Type: SOLD

Description:

Note: D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-
549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S103180



Part: D212-664-101

Job No: 180756

Serial No/Batch: S103180

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, EASA STC SR01298NY 09/01/08, EASA STC

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Stores/Pkg-1		DPZ
110	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-3		DPZ
120	CNC Bend Crosstubes	1 pcs	8/3/18	8/3/18	3.11	2.22	CNC Bend Crosstube		DPZ
130	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC15		DPZ 18-05-21
140	Crosstubes	1 pcs	8/3/18	8/3/18	0.00	0.67	Crosstubes-1		DPZ
150	HandFXtube	1 pcs	8/3/18	8/3/18	0.00	0.98	HandFinish5		DPZ
160	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC7-1		DPZ 18-05-21
165	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		DPZ 18-05-21
170	Outsource	1 pcs	8/3/18	8/3/18			SKY002-VC		DPZ
180	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging2		DPZ AUG 3 1 2018
190	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		DPZ 38
200	SprayPaint	1 pcs	8/3/18	8/3/18	0.00	0.25	Spray Paint		DPZ SEP 09 2018
210	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC14		DPZ SEP 13 2018 68
220	Crosstubes	1 pcs	8/3/18	8/3/18	0.00	1.69	Crosstubes-1		DPZ SEP 13 2018 68
230	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		DPZ SEP 13 2018 68
240	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-3		DPZ SEP 13 2018 89
250	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC4		DPZ SEP 13 2018 68
260	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-1		DPZ SEP 13 2018 68
265	DC	1 pcs	8/3/18	8/3/18	0.00	0.00	DC		DPZ SEP 13 2018 68
270	QC21-FG	1 Ea	8/3/18	8/3/18	0.00	0.00	QC21		DPZ SEP 13 2018 68

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - ***IMMEDIATELY AFTER GRINDING***

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order 10040855

180 - Ensure copy of NDT results attached to work order.

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 138847 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 clear 138832 Paint 138914

210 - Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 138848 EXP: 11/18

PROSEAL CURE TIME 72 HOURS: Start: 18-9-10 Finish: 18-9-13 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - ***RE-CHECK TORQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
D2893-1	Support	2 Ea (2 ea)	220-Crosstubes	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	220-Crosstubes	
MS21920-25	Clamp	4 Ea (4 ea)	220-Crosstubes	
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging	5094566
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging	FM138120-1
D3428-1	Placard	1 Ea (1 ea)	240-Packaging	5046308
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging	5067266
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging	5043782

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-101TRN	1	1	0
220-Crosstubes	D2893-1 5098215	②	7	0
	D3595-063-450 5078312	④	110	0
	MS21920-25 5082848	④	142	0
240-Packaging	AN6-35A	4	61	0
	AN6-36A	4	79	0
	D3428-1	1	31	0
	MS21042L6	6	254	0
	NAS1149D0663J	18	527	0

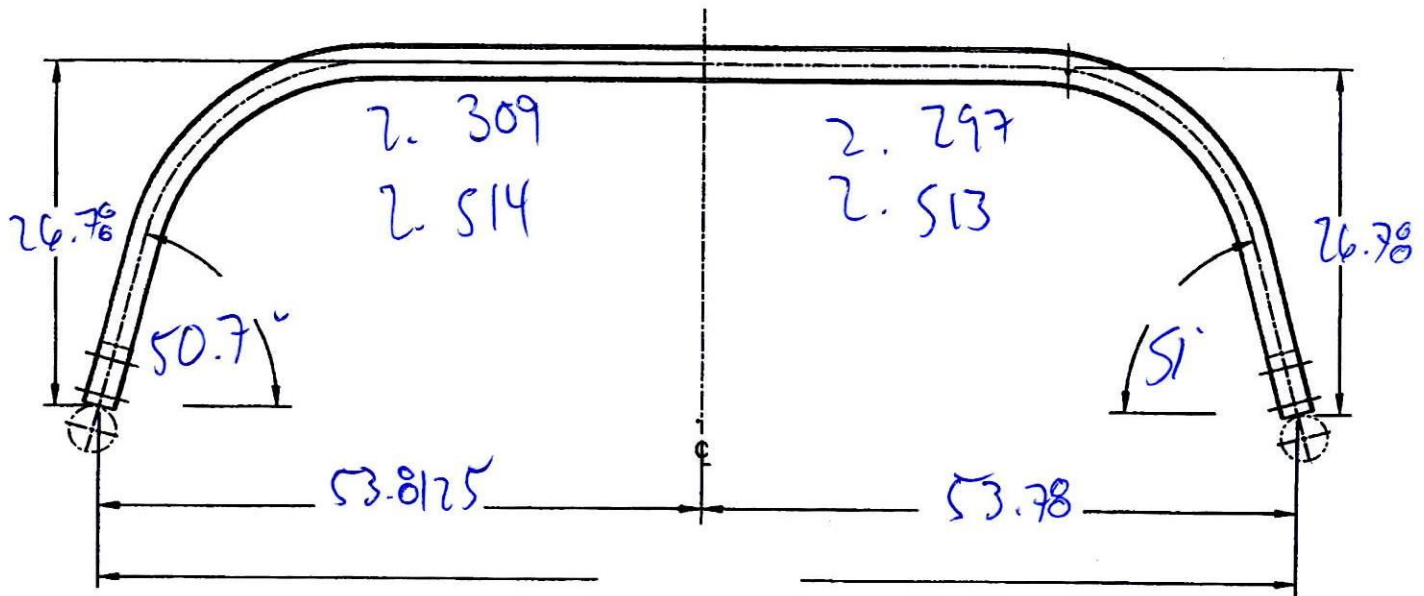
Part Specifications

Specifications could not be found.

Plex 7/13/18 10:53 AM dart.white.jesse

DART AEROSPACE LTD	Work Order:	
Description: Crosstube High Fwd (205/212/412)	Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	8	8
Crushing	4.3%	4.5%
Comments		

QC15 Inspection	28
Date	18-08-16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-684-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-684-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-684-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH -141 & -141B:
 - a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 - c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
 - d) PAINT OUTSIDE PER DART QSI 005 4.2
 - e) REMOVE MASKING AND APPLY MATTE CLEAR COAT

- a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
- b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
- c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
- d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
- e) PAINT OUTSIDE PER DART QSI 005 4.2
- f) REMOVE MASKING AND APPLY MATTE CLEAR COAT

***NOTE:** BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-684-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- 7) WEIGHT: D212-684-141/-141B/-141F = 33.6 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- 10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

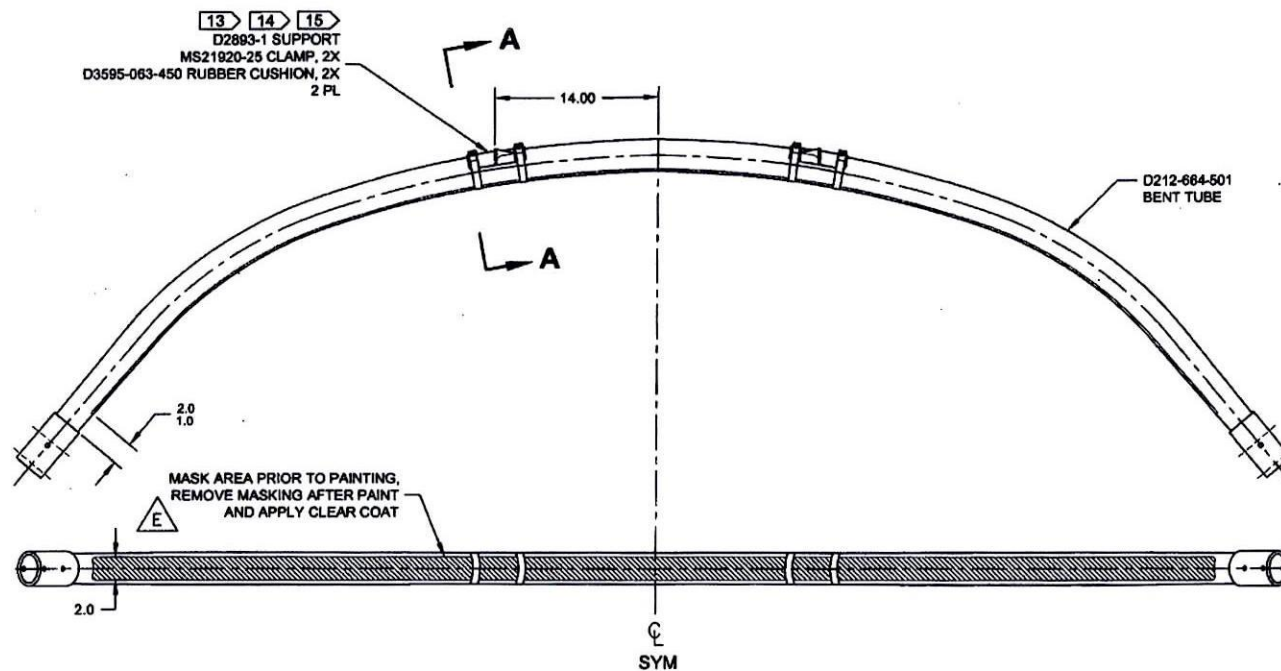
ASSEMBLY

- 13) TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 14) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

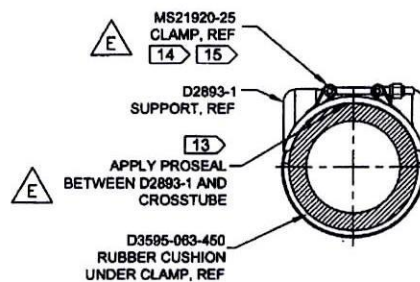
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2014-05-26
WJD

E	ADD -141F, D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.26 WAS 0.13 (C1-3), INCORP. DEO D-1/-2/-3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-045 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6396, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-684-141	REV. E SHEET 1 OF 5
TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE NTS
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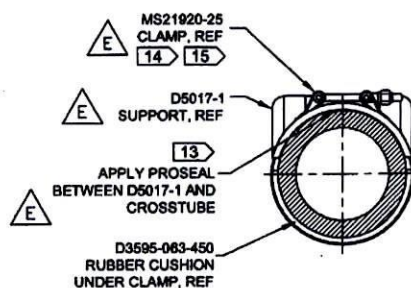
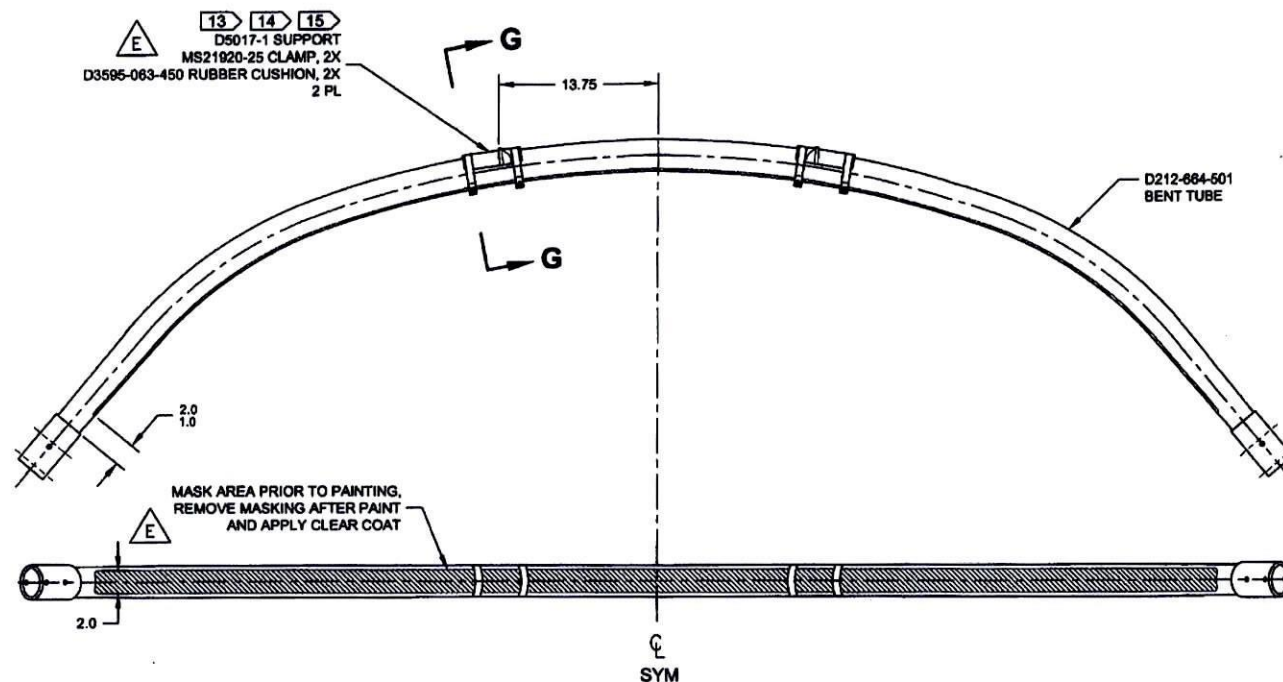
**D212-664-141/-141F
ASSEMBLY DETAIL**



SECTION A-A
SCALE 4X

RELEASED
2014-05-26
ND

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D212-664-141 SHEET 2 OF 6
APPROVED		TITLE SCALE
DE APPR.		XTUBE ASSY (205/212/412 HI FWD) NTS
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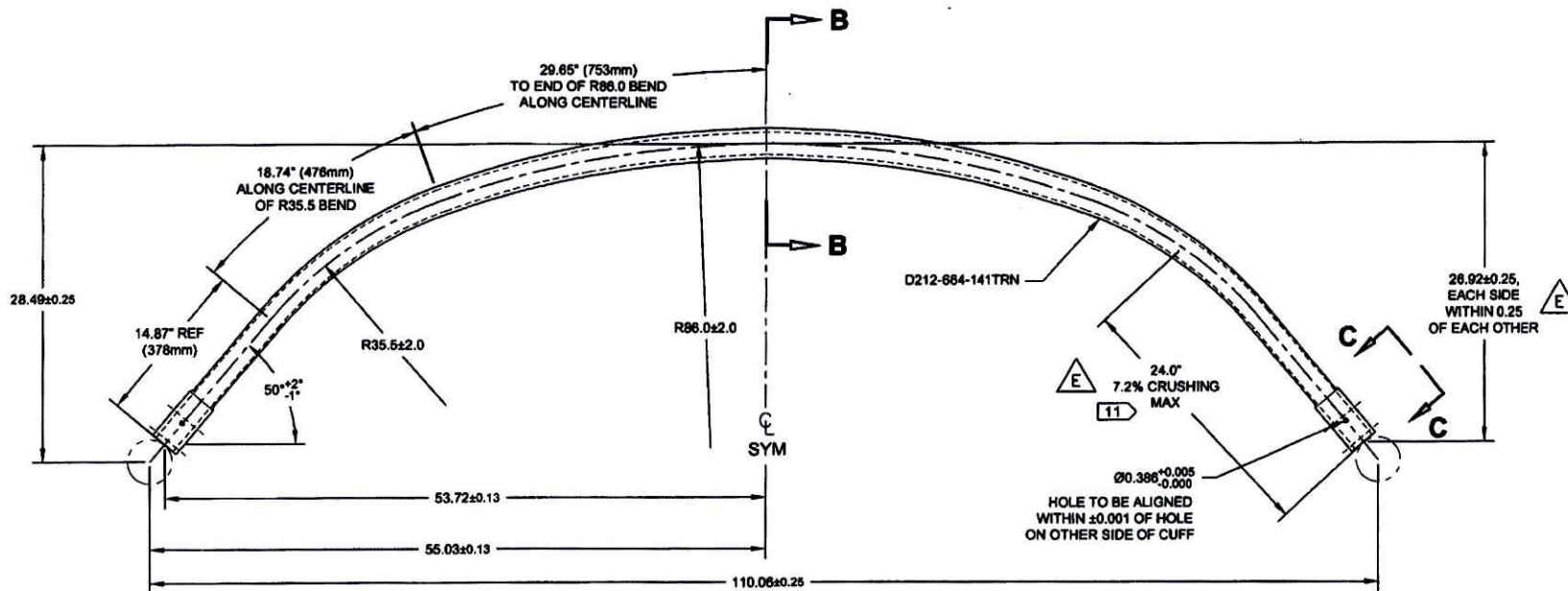


SECTION G-G
SCALE 4X

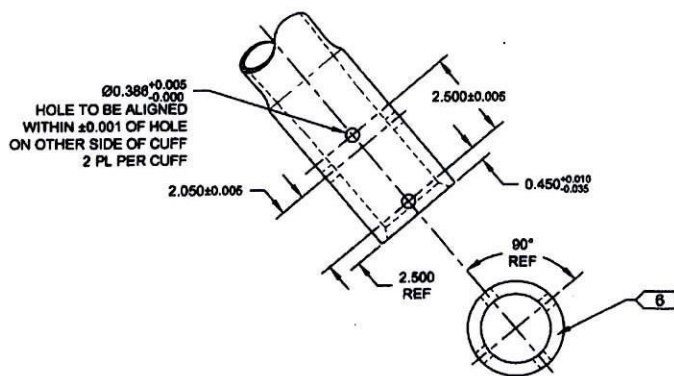
D212-664-141B
ASSEMBLY DETAIL

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2014-05-26

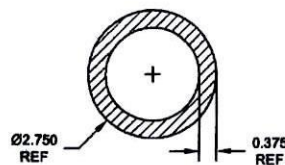
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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	DL	DRAWING NO. REV. E
MFG. APPR.		D212-664-141 SHEET 3 OF 6
APPROVED		TITLE SCALE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD) NTS
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D212-664-501
BENDING AND DRILLING DETAIL 11



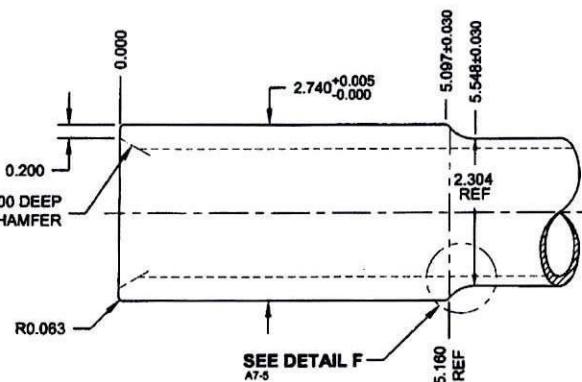
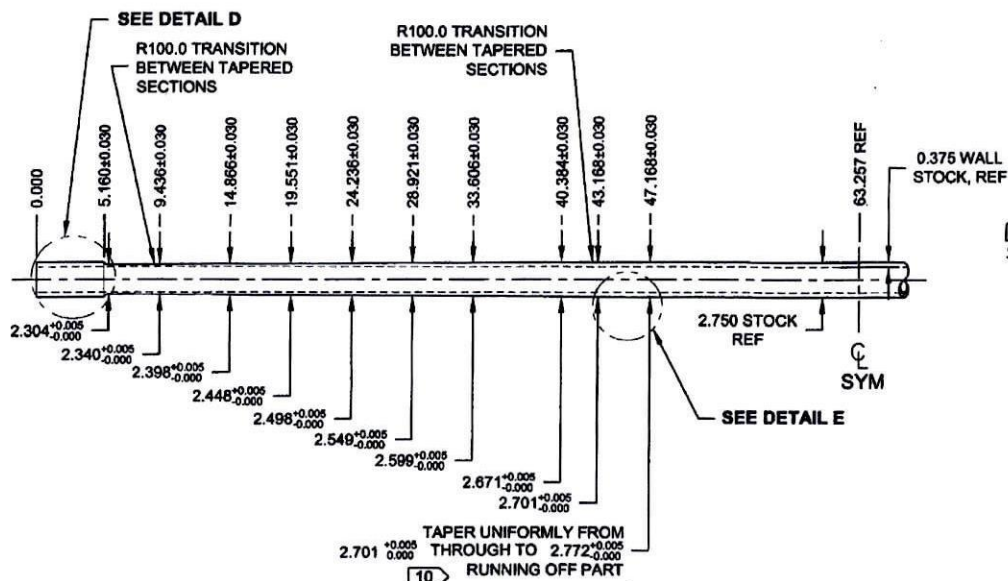
VIEW C-C: CUFF DETAIL
SCALE 3X



SECTION B-B
SCALE 4X

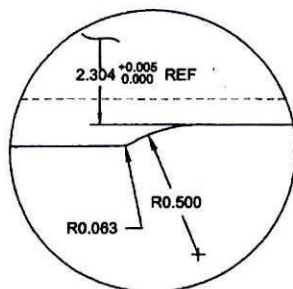
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2014-05-26

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 4 OF 5
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DE APPR.		XTUBE ASSY (205/212/412 HI FWD)	NTS
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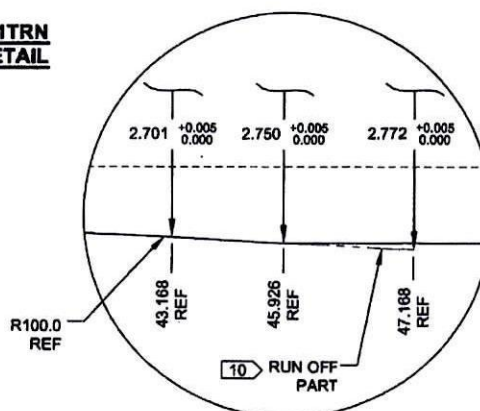


DETAIL D:
CROSSTUBE CUFF
SCALE 5X

D212-664-141TRN
TURNING DETAIL



DETAIL F:
CUFF TRANSITION
SCALE 10X



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

RELEASED
2014-05-26

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. E
MFG. APPR.	90	D212-664-141	SHEET 5 OF 5
APPROVED	90	TITLE	SCALE
DE APPR.	90	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37249	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040895
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

1 FUEL TANK ASSY, P/N# D4464-041 , J/S# 180616 / - rework

3 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 180756, 180757, 180758

4 RAPPEL SLIDE BARS , P/N# D3011-1 , J/S# 180423

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16						AUG 30 2018	 DOT-APP 20 53-89
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELKIAN	 DOT-APP 20 53-89	AUG 30 2018

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	QTY -101	QTY -201	QTY -203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21920-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21920-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21920-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

* REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE.

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI SKIDTUBES.